

Split SB 07/05/08

Date: Tuesday, 01/05/2007 2:22:17 PM
User: Linda Lacelle

Process Sheet

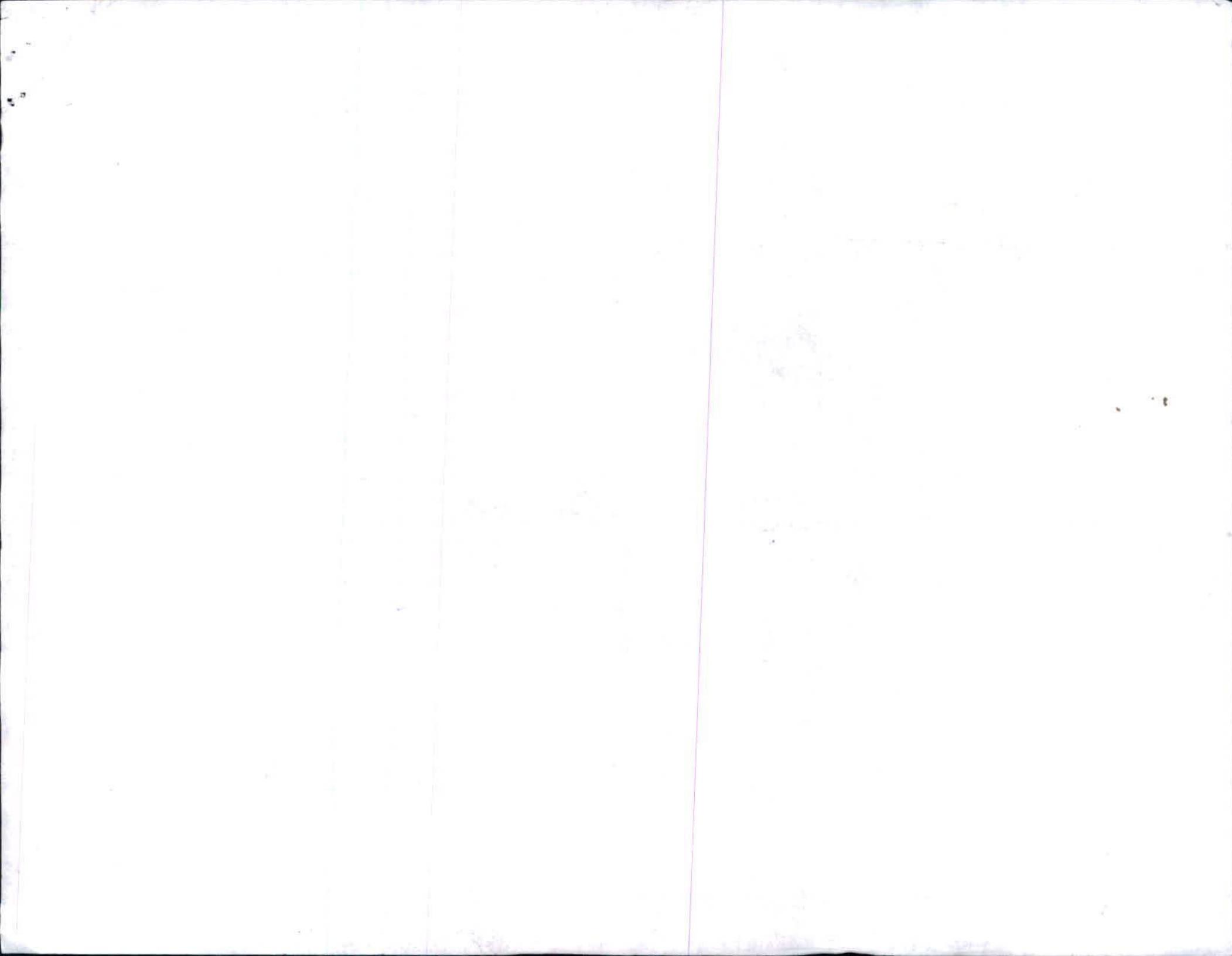
Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	GUIDE ASS'Y
Job Number	31913-1	Part Number	D35725
Estimate Number	12706	Drawing Number	D3572 REV B
P.O. Number	N/A	Project Number	N/A
This Issue	01/05/2007	Drawing Revision	B
Prsht Rev.	NC	Material	N/A
First Issue	N/A	Due Date	13/05/2007
Previous Run	31913	Qty:	63
Written By		Um:	Each
Checked & Approved By			
Comment	Est Rev :A New Issue 07-01-16 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6S080	6061-T6 .080 Sheet	
		Comment: Qty.: 0.0315 sf(s)/Unit Total : 1.8900 sf(s) 6061-T6 .080 Sheet Batch: M104186	SAB 07/05/04
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D3572 Dwg Rev: B Prog Rev:	SPN 07/05/04 JLM 07/05/07
		2-Deburr if necessary	(63) (63)
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	SAB 07/05/04 (63)
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	EM 07/05/04 (63)
5.0	BRAKE NC	NC BRAKE	
		Comment: NC BRAKE form bend as per Dwg D3572 usin DT8943	SB 07/05/18 (63)



Date: Tuesday, 01/05/2007 2:22:17 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GUIDE ASS'Y

Job Number: 31913

Part Number: D35725

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



2070518



Comment: INSPECT WORK TO CURRENT STEP

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *WA 29*

LK 01-05-18

40

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

40 010522

Job Completion



207105122



Date: Tuesday, 4/17/2007 3:55:08 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	GUIDE ASS'Y		
Job Number	31913			Part Number	D35725		
Estimate Number	12706			Drawing Number	D3572 UNDER REVIEW		
P.O. Number	:			Project Number	N/A		
This Issue	4/17/2007	S.O. No.	:	Drawing Revision	U/R		
Prsht Rev.	NC			Material	:		
First Issue	/ /	Type	SMALL /MED FAB	Due Date	5/12/2007	Qty:	60
Previous Run	31477			Um:	Each		
Written By	:						
Checked & Approved By	:						
Comment	Est Rev <input checked="" type="checkbox"/> New Issue 07-01-16 JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S080	6061-T6 .080 Sheet
	Comment: Qty.: 0.0315 sf(s)/Unit Total : 1.8900 sf(s) 6061-T6 .080 Sheet Batch: _____	
2.0	WATER JET	FLOW WATER JET
	Comment: FLOW WATER JET 1-Cut as per Dwg D3572 Dwg Rev: _____ Prog Rev: _____ 2-Deburr if necessary	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK
	Comment: SECOND CHECK	
5.0	BRAKE NC	NC BRAKE
	Comment: NC BRAKE form bend as per Dwg D3572	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>##</i>	APPROVED <i>##</i>	DRAWING NO. D3572
DATE 07.03.29	TITLE GUIDE ASSEMBLY	SCALE 1:4

REV	DATE	DESCRIPTION
A	07.03.29	NEW ISSUE

RELEASED

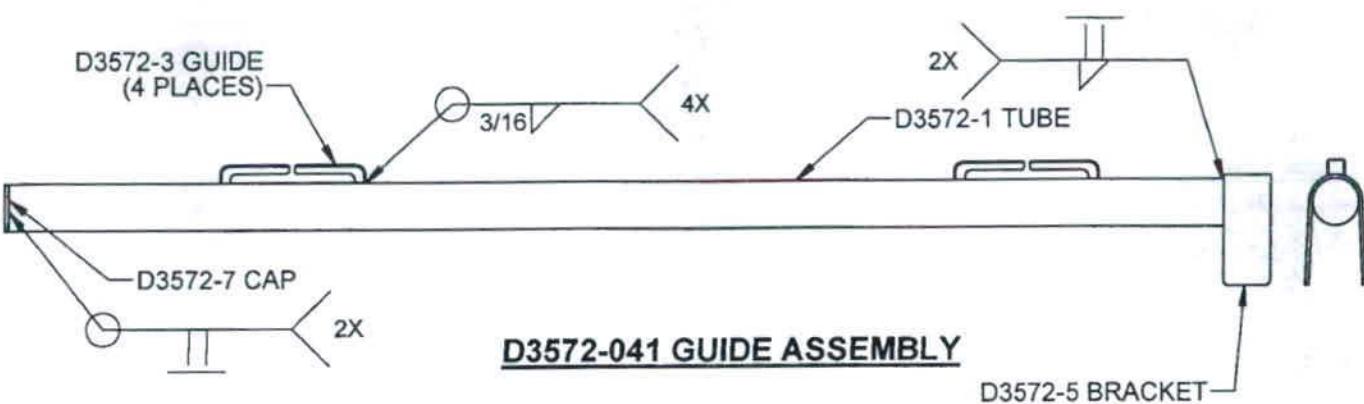
07.04.12 *##*

19.28

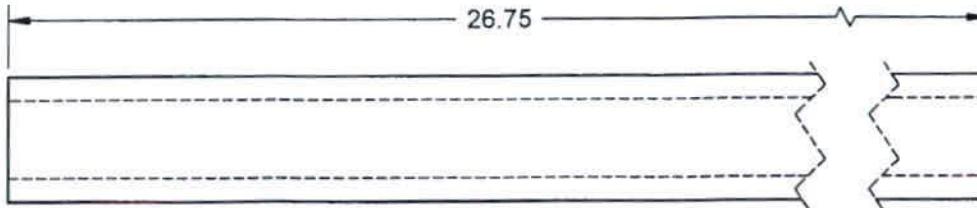
0.125

3.66

C

D3572-041 NOTES:

- 1) PART IS SYMMETRIC ABOUT CENTERLINE
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3572-041" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) WELD PER DART QSI 004

D3572-1 TUBE

SHOP COPY
RETURN TO
ENGINEERING
Ø1.000 (REF)
INCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. _____

D3572-1 NOTES:

- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM TUBE 1.00 OD X 0.188 WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8
(REF DART SPEC M6061T6T1.000W.188)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

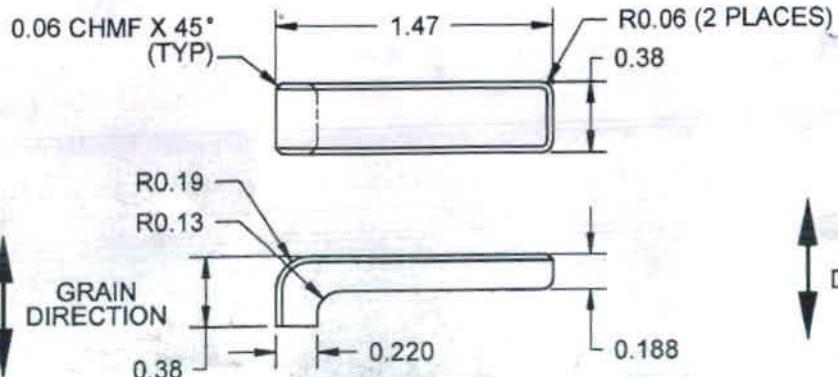
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DART

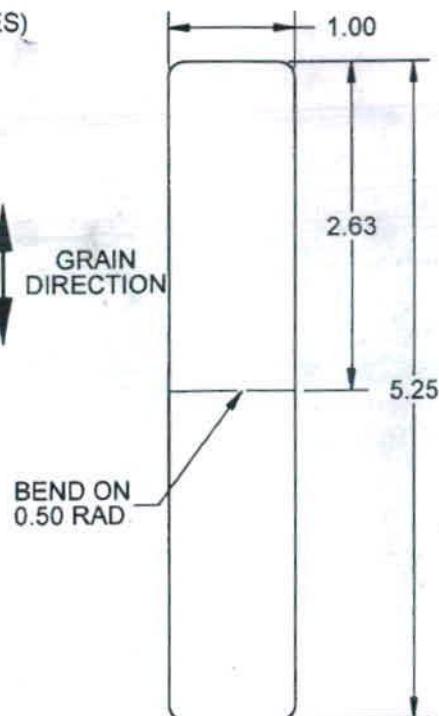
DESIGN <i>CE</i>	DRAWN BY <i>CE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MM</i>	APPROVED <i>MM</i>	DRAWING NO. D3572	REV. A SHEET 2 OF 2
DATE 07.03.29	TITLE GUIDE ASSEMBLY	SCALE 2:3	



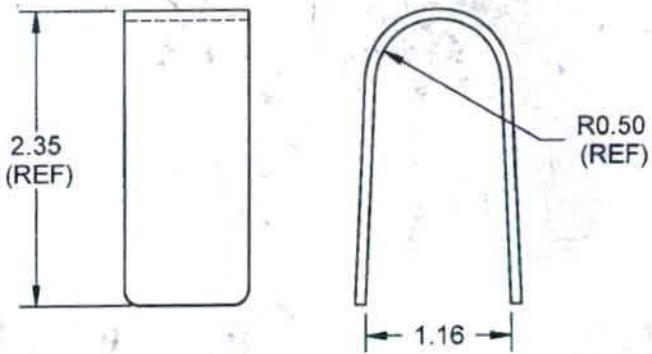
1 **D3572-3 GUIDE**

RELEASED

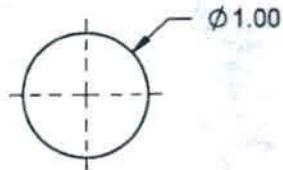
07.04.12 *MM*



2 **D3572-5 FLAT PATTERN**



D3572-5 BRACKET
(MAKE FROM D3572-5F)



2 **D3572-7 CAP**

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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

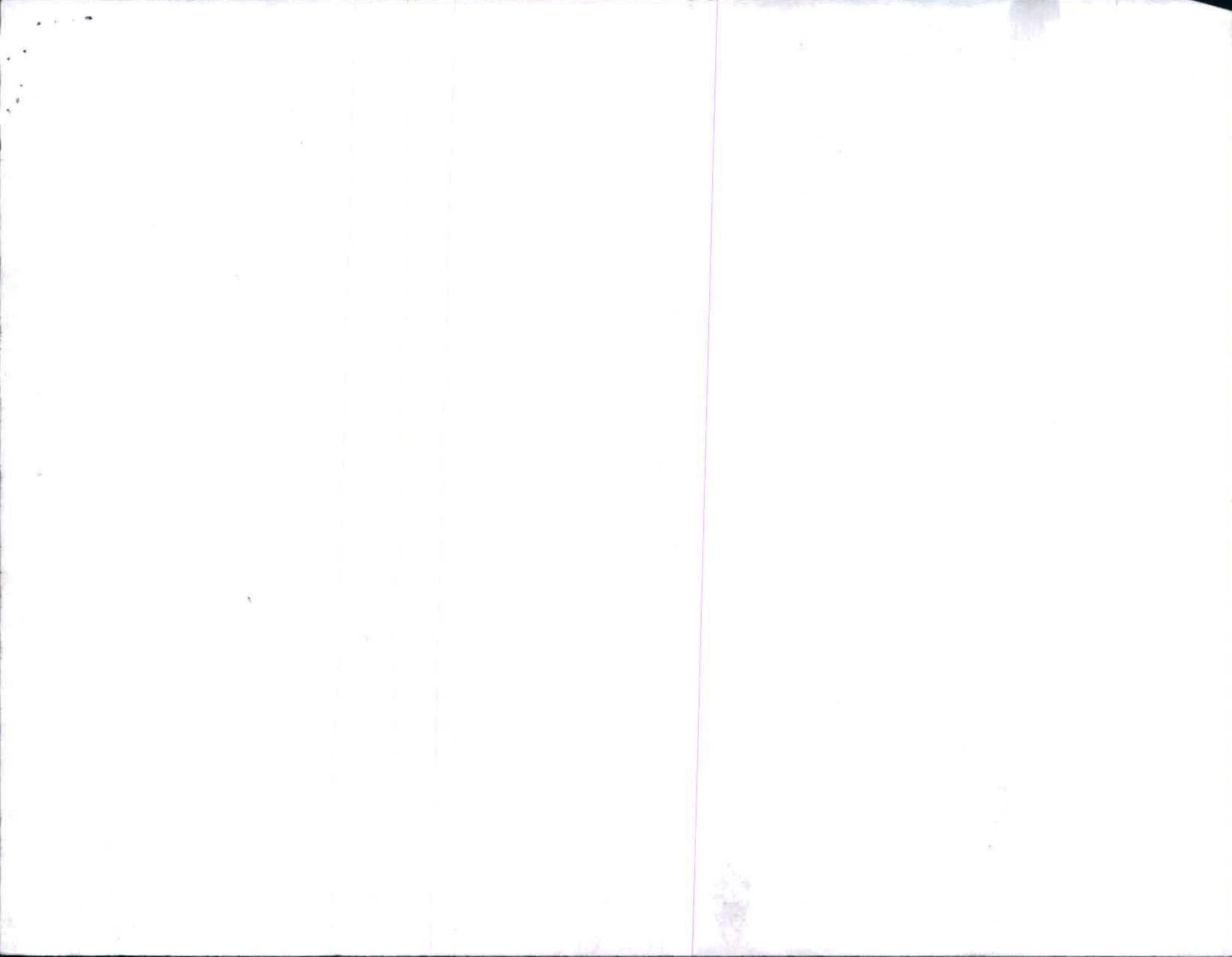
NO.

D3572-3/5-7 NOTES:

- 1) D3572-3 MATERIAL: 6061-T6 (OR T651/T6510/T651/T62) ALUMINUM BAR PER QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 (OR AMS 4160) (REF DART SPEC M6061T6B)
- 2) D3572-5/-7 MATERIAL: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK PER QQ-A-250/11 OR AMS 4025 OR 4027 (REF DART SPEC M6061T6S.080)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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DART AEROSPACE LTD

Work Order: 31913

Description Guide Ass 'YI

Part Number: D35725

Inspection Swg: D3572 Rev: B

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

SAD

Facilitated by:

Prototype Approval

04/05/09

Date:

20
07/05/04

四

W/A

Date Change

Revised by Approved

六三

